

**Work Order ID 57855**

Monday, April 19, 2010 1:47:13 PM



Page 1

Item ID: D4040-1

Accept



Setup Start



Revision ID:

Item Name: Radius Block

Stop



Start Date: 4/19/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 4/26/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

*MF*Date: *10-4-19*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4040

A

100

Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

*aml 10/04/20**12* *Ø*

Jeaspa Bandsaw

CUT BLANK 6.050" LONG

105

0.00



HAAS 1

Memo

0.00

*aml 10/04/20**12* *Ø*

HAAS CNC vertical machine #1

MILL AS PER DWG AND FOLIO FA890

DWG REV: *1*FOLIO REV: *AA*

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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QC:

Date:

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Date:

Stop

Sequence ID/  
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DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

and 10/04/21

12 0

Quality Control

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

10/04/22

12 0

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

10/04/22

12 0

Hand Finishing

W/O:		WORK ORDER CHANGES					
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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

(12)

BR 10-4-22.

160

Identify as per dwg & Stock Location: *10*

0.00



Packaging

Memo

0.00

Packaging

10-4-26 *df* (20)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/27 *df*

MF 10-4-26

W/O:		WORK ORDER CHANGES					
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# Picklist Print

Monday, April 19, 2010 1:47:13 PM

Page 1

Work Order ID: 57855



Parent Item: D4040-1



Parent Item Name: Radius Block

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: Ipp Rev:A New Issue 09-12-14 JLM Verified By:EC

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.375X00.75 0		Purchased	No			100	f	25.2000	1.1368			



6061T6 BAR .375 x .750

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

25.2

10829

5.2

113719

20

1.1368 mkl 10/04/20

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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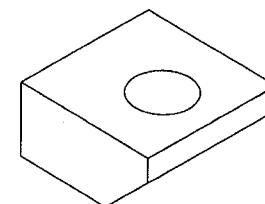


## Remember....

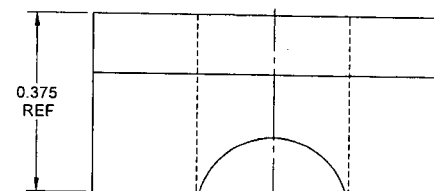
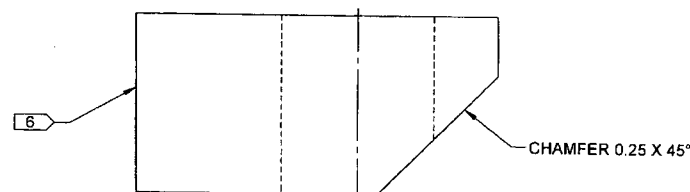
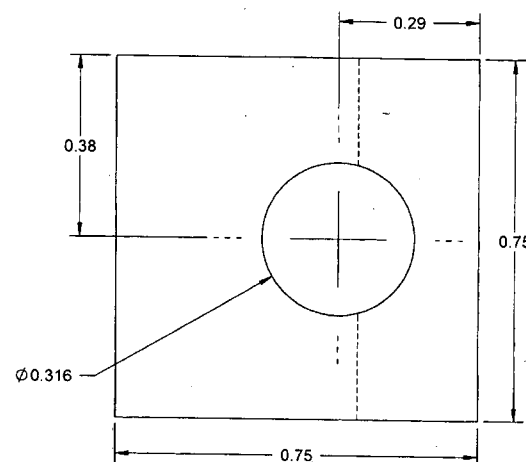
- Lean is war to WASTE.
- Waste is an activity or output that ***adds cost but does not add value***
- You have to get into a mindset of identifying and eliminating all wastes.

### The 7 deadly wastes

- |  |  |
|--|--|
| 1. <b><i>Overproduction</i></b>        | 2. <b><i>Rework</i></b>                          |
| 3. <b><i>Transportation</i></b>        | 4. <b><i>Inappropriate / over Processing</i></b> |
| 5. <b><i>Unnecessary Inventory</i></b> | 6. <b><i>Delays / Waiting</i></b>                |
| 7. <b><i>Unnecessary Motions</i></b>   |  |



#57855



**D4040-1 RADIUS BLOCK**

RELEASED  
2010-04-14  
MD

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR, 0.375 THICK  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF DART SPEC M6061T6B0.375
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4040-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs

A		NEW ISSUE		09.12.11	
REV.	DESCRIPTION	BY	DATE		
DESIGN				<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN					
CHECKED				DRAWING NO.	REV. A
MFG. APPR.				D4040	SHEET 1 OF 1
APPROVED				TITLE	SCALE
DE APPR.				RADIUS BLOCK	NTS
DATE	09.12.11	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

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